

Work Order ID 127306

127306

Page 1

December-17-14 1:12:30 PM

Item ID: D4364-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Run-on Landing Wearplate Fwd
 Start Date: 12/17/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4364	B								

150 0.00

150

Large Fab

Large Fab

Memo

0.00

1- on D4365-1, fill cut outs with hardcoat welding rod as per dwg D4364 **USE DT9756**

2059 B Hardcoat Welding Rod

BATCH#: M130852

2-weld D4365-1 to wearplate by positioning holes together as per dwg D4364

304 S.S. Welding Rod

BATCH #: M123823

3-Transfer drill holes in bar

4 14-1-12 Q /MAL

160

QC9- Inspect visual per QSI004- Fusion Welds 0.00

160

QC

Quality Control

Memo

0.00

④ 15-01-12

DAS

9

9-89

DQA:

Date: 15/03/19

QA Closed:

Date: 15/3/15

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACEWork Order update only ☐

Work Order: 127306	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. D4364-041		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☒
NCR No. 15-46006		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☒	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15-01-12	150	4	wearplate was modified from flat pattern to fit bent skid tube due to gap on skid tube to wearplate. Was slit down the middle of fwd end from start to 3rd slot; fit, then tacked/welded	MP 15/1/12	Modify as instructed in Description	EL 15-1-12	15-01-12	S 15/01/12
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport						Put Design under Review on Raw PAR.	W 15/03/06		
Unapproved									

R.C. Design

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☒ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

December-17-14 1:12:30 PM

Stop *NS2*

Customer:

Reference:

Stop ***NR2***

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

180

180

Small Fab

Small Fab

0.00

Memo

0.00

1- After finish, coat entire top (concave) surface as per note 10 on sheet 2 dwg D4364.

TESTURED COATING B#: 131025

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
38
9-89

JAN 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127306***127306***

Page 3

Item ID: D4364-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Run-on Landing Wearplate Fwd

Start Date: 12/17/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location 1-12-00 2

0.00

200

Packaging

Memo

0.00

Packaging

x4 d 18/01/13

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MLG 1501-14

UMF

15-173

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:12:30 PM

Page 1

Work Order ID: 127306

127306

Parent Item: D4364-041

D4364-041

Parent Item Name: Run-on Landing Wearplate Fwd

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC IPP
REV:B 14.04.22 DWG B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4364-1		Manufactured	No				Each	9.0000		4			

D4364-1
Plate

EL 15-1-9

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA001	9	
<u>123514</u>	6	
125417	3	

48 4

D4365-1		Manufactured	No			150	Each	18.0000	1	4			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4365-1
Bar

EL 15-1-15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA001	18	
103297	4	
123470	2	
<u>125326</u>	12	

4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

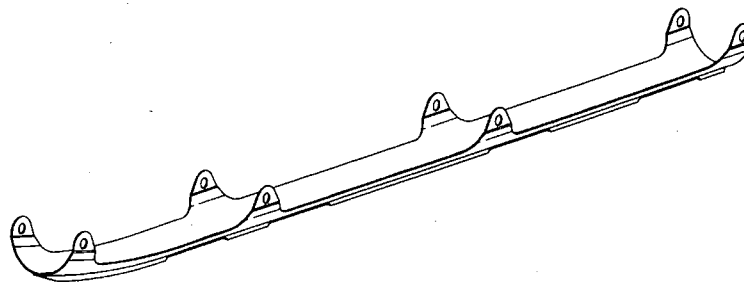
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

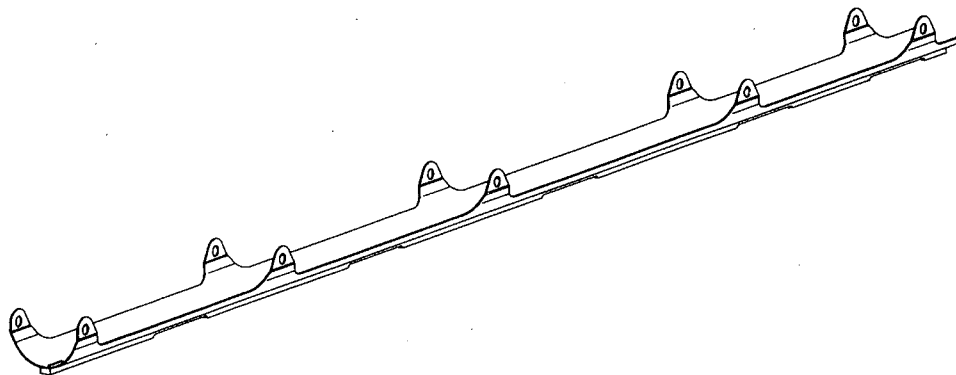
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Folio/Program
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear
☐ Crushing	☐ Countersink	☐ Misaligned/off center
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set
☐ Turning Sequence	☐ Finish	☐ Out of Calibration
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence
		☐ Outside Dimensions
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Set-up
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other



D4364-041 FWD WEARPLATE ASSY



D4364-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X		D4364-041	FWD WEARPLATE ASSY
		X	D4364-043	AFT WEARPLATE ASSY
1	1		D4364-1	PLATE
2		1	D4364-3	PLATE
3	1		D4365-1	BAR
4		1	D4365-3	BAR
5	A/R	A/R	2059B	HARDCOAT
6	A/R	A/R	TEXTURED COATING	SEALANT

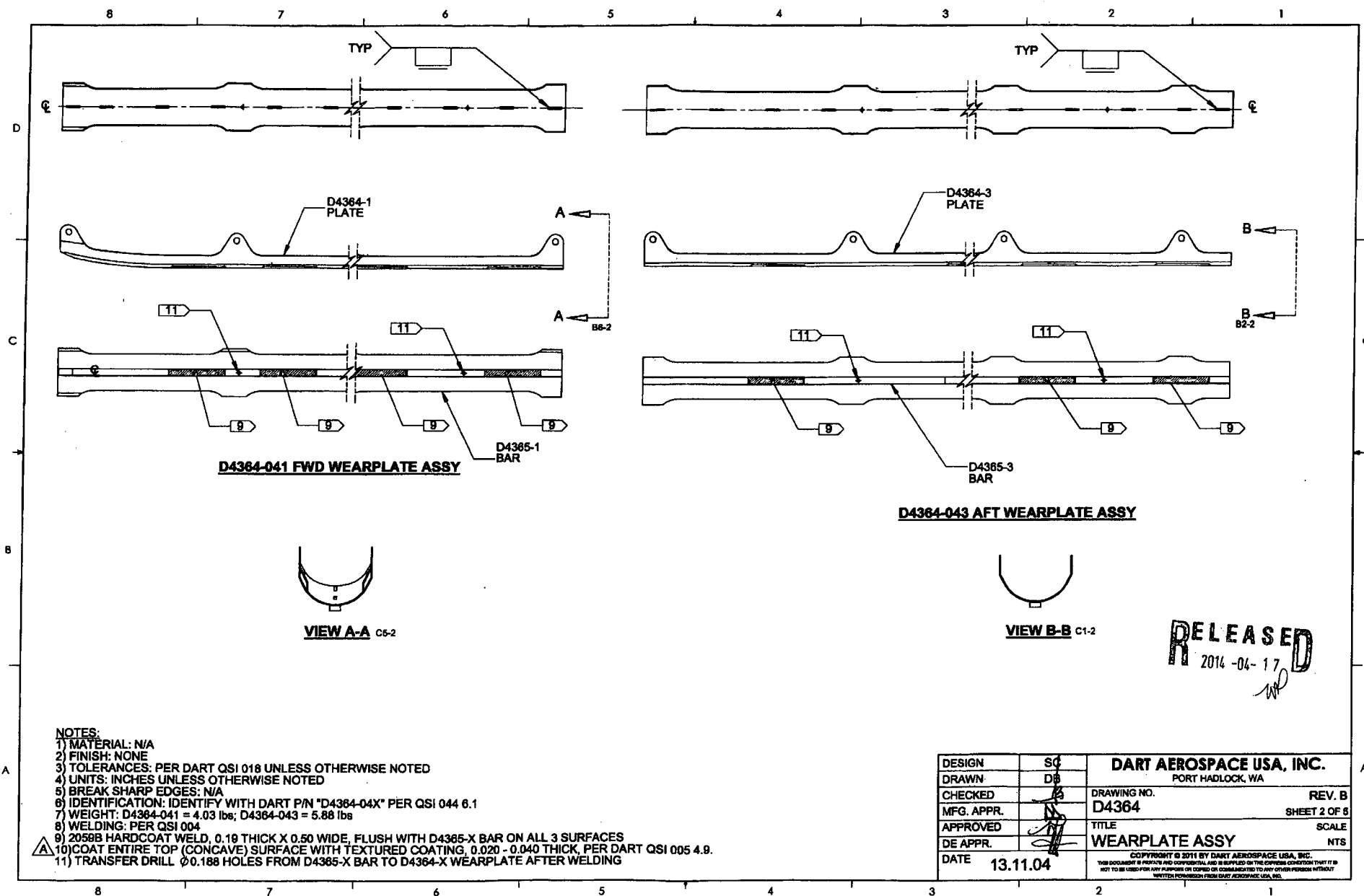
△B

FROM COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NOT TO AMENDMENT
WORK ORDER

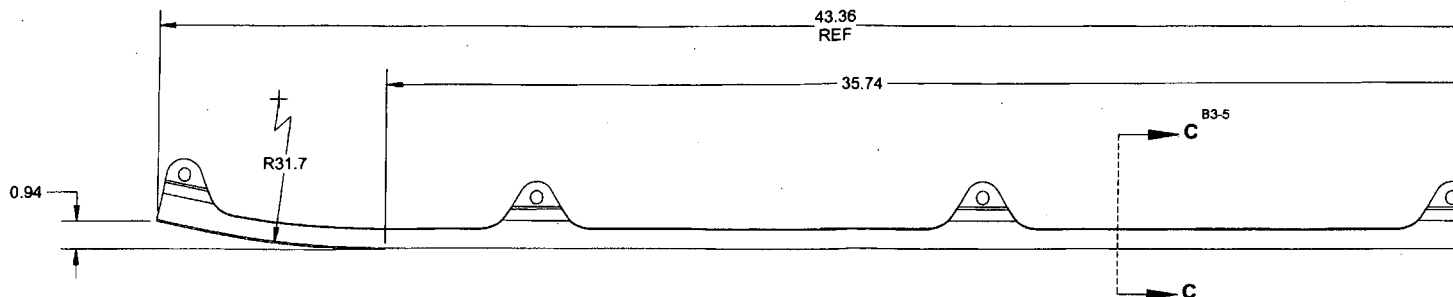
127306 MJS
14-12-18

RELEASED
2014-04-17
vmo

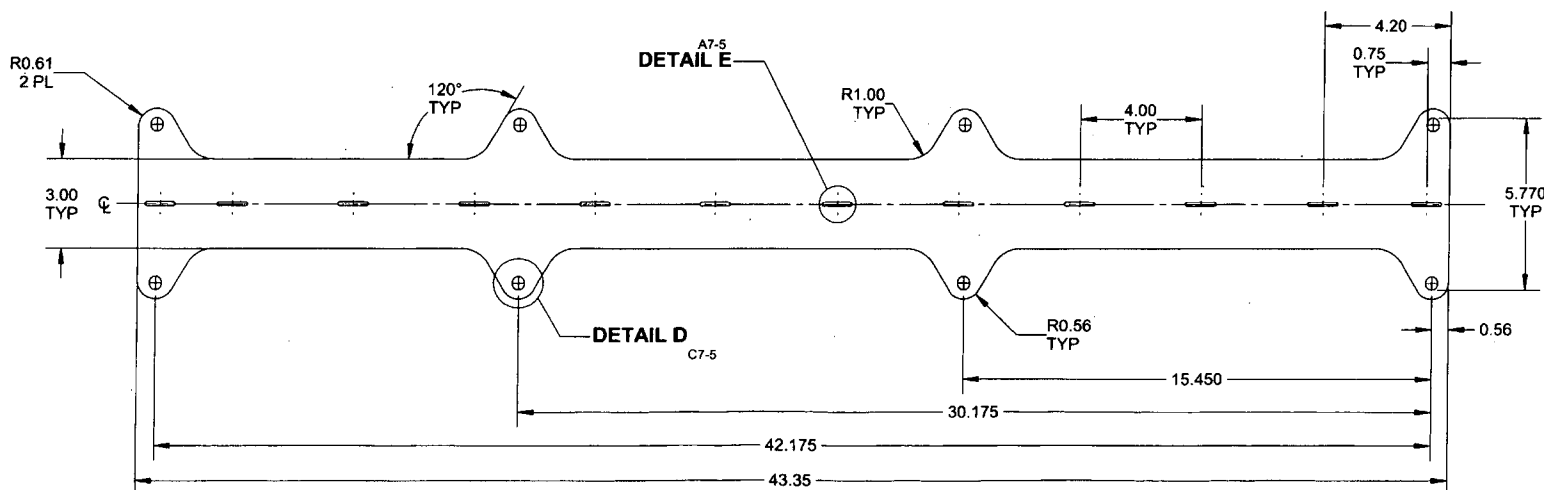
B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), CHANGE NOTE 10 (SH 2)	DB	13.11.04
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	DB		
CHECKED	BS	DRAWING NO.	REV. B
MFG. APPR.	BS	D4364	SHEET 1 OF 5
APPROVED	BS	TITLE	SCALE
DE APPR.	BS	WEARPLATE ASSY	NTS
DATE	13.11.04	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



8 7 6 5 4 3 2 1



D4364-1 PLATE
(MAKE FROM D4364-1F)



D4364-1F PLATE

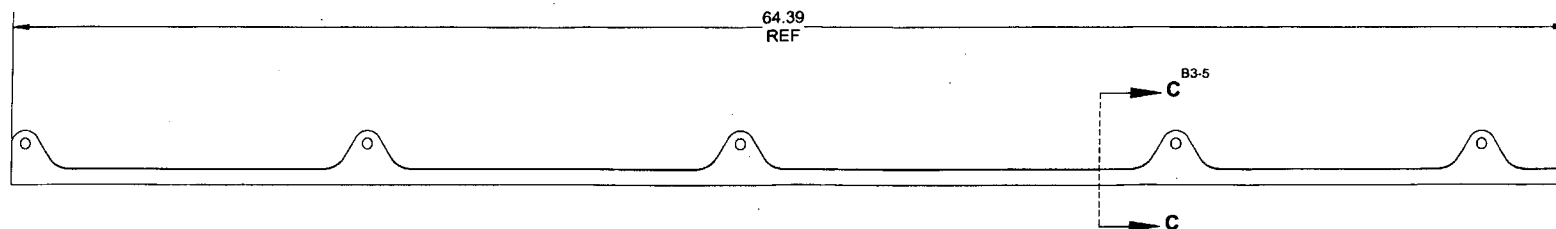
RELEASED
2014-04-17

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.12 lbs

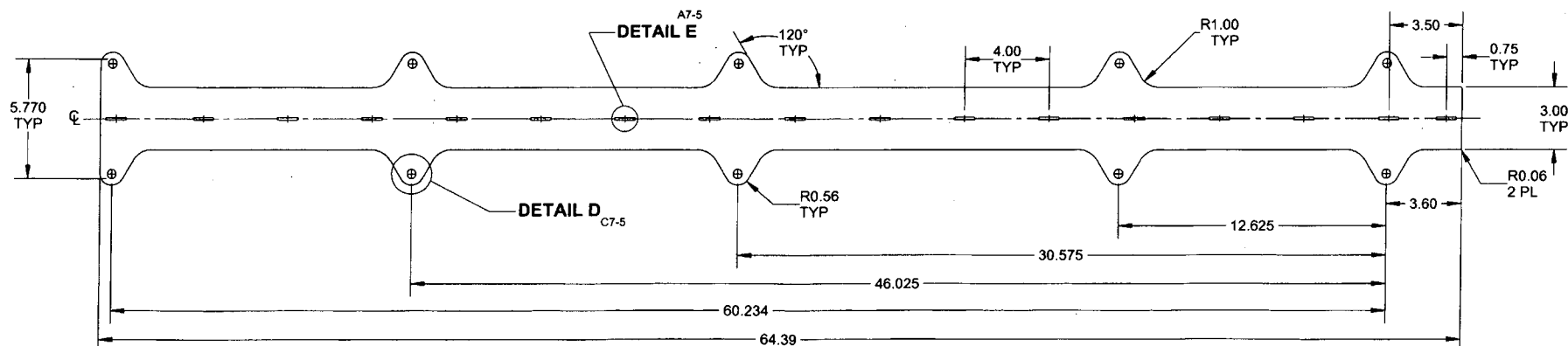
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4364	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4364-3 PLATE
(MAKE FROM D4364-3F)



D4364-3F PLATE

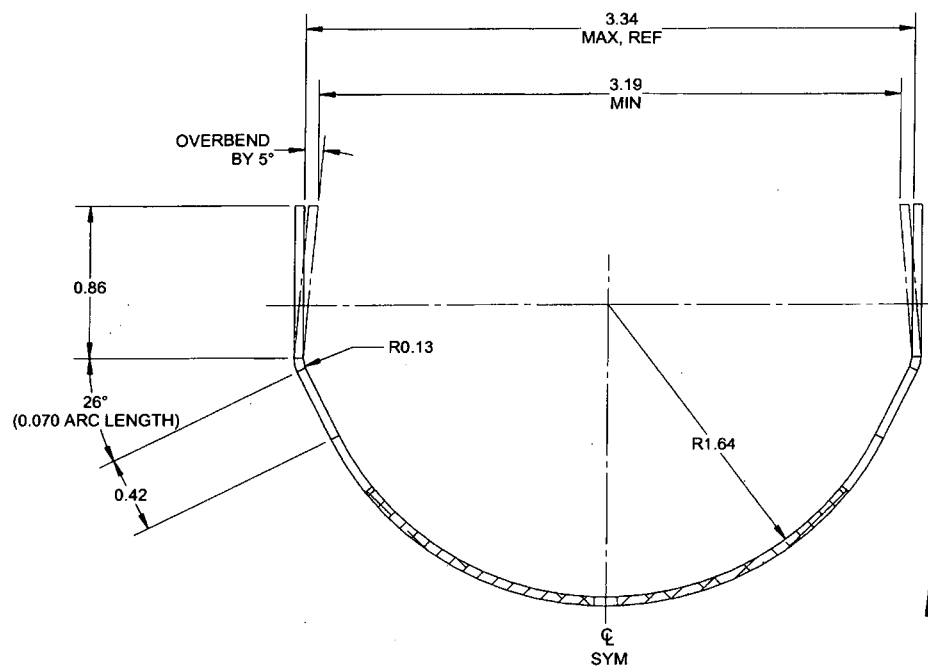
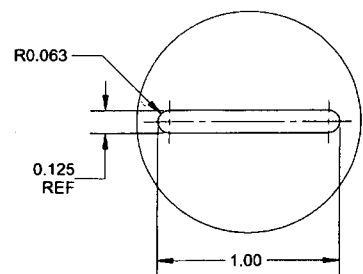
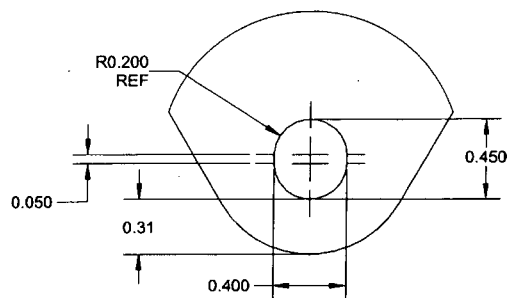
RELEASED
2014-04-17

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.10 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4364	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



RELEASED
2014-04-17

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4364	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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